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STANDARD WELDING PROCEDURE SPECIFICATION #_6AH65

A. Process: Manual Electric Arc
B. Material: API-5L Grade X65
C. Diameter and Wall Thickness: OVER 12 IN. and >.188—THRU .750 WT
D. Joint Design: Standard Vee Groove 30 degrees
E. Filler Metal and Number of Beads: Electrode Classification
Electrode E6010 and E8010 AWS Class A 5.1-A 5.5 Minimum of 4 Passes
F. Electrical or Flame Characteristics: D.C. Reverse Polarity, Electrode Positive
G. Position: Fixed Horizontal
H. Direction of Welding: Vertical Down
I. Number of Welders: 1
J. Time Lapse Between Passes: Maximum of 5 minutes between stringer and hot pass; 3 minutes maximum when temperature is below 35° F.
K. Type of Line-Up Clamp: External
L. Removal of Line-Up Clamp: After 50% completion of stringer bead
M. Cleaning: Taper grind starts and craters and flatten crown by grinding stringer bead, power buff all remaining passes.
N. Speed of Travel: Stringer bead 9--12 inches per minute maximum.
O. *Preheat, Stress Relief: Maximum of 300°F. Minimum of 150°F. Preheating shall be done with device or equipment which will heat entire circumference(s) in single application 2" back from pipe ends.
P. Notes: Welded pipe strings shall be temporarily capped to prevent air draft cooling of stringer beads. Weld shall be completely protected from moisture until it has cooled to ambient temperature. Weld zone shall be protected so that the wind velocity near it does not exceed 8 miles per hour.

*X-Rated pipe must be stress relief if the carbon content exceeds .032% or C+1/4 Mn exceeds .065%. Heating of X-Rated pipe is limited to 600°F.

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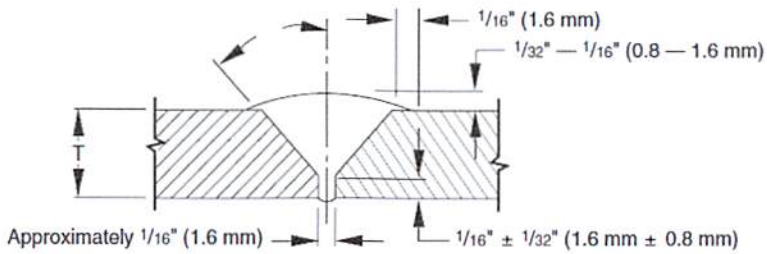
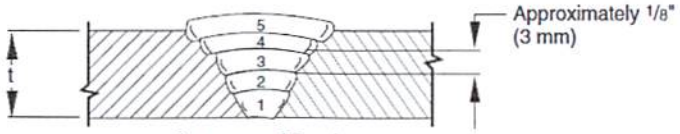


Standard V-Bevel Butt Joint



Sequence of Beads

Note: Dimensions are for example only.

Bead No.	Electrode Diameter	Amperage Range	Voltage Range	Type Rod	Notes
1	5/32	130-170	25-32	5P+	
2	3/16	130-190	26-36	70+	See Below
3	3/16	135-195	25-35	70+	
4	3/16	135-195	25-35	70+	
5	3/16	125-180	25-35	70+	

Bead No.	Notes
1-5	Electrodes may be substituted within Rod group AWS A5.1—A5.5
2	Hot Pass may be made using 5/32 within same Amperage Range
4	Additional passes may be made at same settings

WELD TEST REPORT

(USE SEPARATE FORM FOR EACH WELDING PROCEDURE)

DATE	WELDER'S NAME	SOCIAL SECURITY NUMBER
8-7-19	Chris Epps	

LOCATION	NAME OF CONTRACTOR OR COMPANY	RIGHT HANDED ☑ LEFT HANDED ☐	REQUALIFYING TEST ☑ QUALIFYING TEST ☐ LINE TEST ☐
Guymon	WTG		

POSITION	ELECTRIC ARC ☑ INDOORS ☐ OX-ACETYLENE ☐ OUTDOORS ☑	WEATHER	TEMPERATURE	TIME OF DAY	WIND BREAK USED
INCLINED ☐ FIXED ☑ HORIZONTAL ☑		CL	95°	Mid	N/A

PIPE SPECIFICATION	PIPE MANUFACTURER	WALL THICKNESS	DIAMETER (OD)	WEIGHT PER FOOT
API 5L X 65	IPSCO	.500	20	104

MAKE OF WELDING MACHINE	SIZE	MAKE OF OX-ACETYLENE APPARATUS	WELDING NOZZLE SIZE	OX-ACETYLENE PRESSURE FLOWING
LiN	200	N/A	N/A	N/A

BRAND OF ELECTRODE	BRAND OF OX-ACETYLENE ROD AND SIZE	NUMBER OF PASSES - OX-ACETYLENE WELD	WELDING PROCEDURE NO.
LiN	N/A	N/A	6AH65

PIPE WELD

	ELECTRODE TYPE AND SIZE	MACHINE SETTINGS COARSE	MACHINE SETTINGS FINE	AMPERAGE RG.	VOLTAGE RG.
STRINGER	LiN 5PT 5/32	160-240	55	130-170	25-32
HOT PASS	LiN 70T 3/16	160-240	80	130-190	26-36
FILLER (S)	LiN 70T 3/16	160-240	70	135-195	25-35
CAP PASS	LiN 70T 3/16	160-240	70	125-180	25-35

Qualifying Test for 6AH65 Visual Acc

TENSILE TESTS

	COUPON LOCATION	COUPON LENGTH	COUPON WIDTH	CROSS SEC. AREA SQ. IN.	LOAD	% ELONG.	COMPUTED TENSIL PSI	REMARKS	ACCEPTED	REJECTED
1	TA	9"	1"	.50	39,000	15%	78,000	No defects	✓	
2	BA	〃	〃	〃	〃	〃	〃	〃	✓	
3	TB	〃	〃	〃	〃	〃	〃	〃	✓	
4	BB	〃	〃	〃	〃	〃	〃	〃	✓	

BEND TESTS

	COUPON LOCATION	TYPE OF BEND	REMARKS	ACCEPTED	REJECTED
1	AB Root AT Face	No defects		✓	
2	AB Root AT Face	Small Hydrogen No defect		✓	
3	BB Root BT Face	No defects		✓	
4	BB Root BT Face	No defects		✓	

NICK-BREAK TESTS

	COUPON LOCATION	REMARKS	ACCEPTED	REJECTED
1	TA	No defect	✓	
2	TB	Small slag 1/64	✓	
3	BA	No defect	✓	
4	BB	Small Hydrogen Pickup	✓	

TEE WELD TEST

SIZE AND WALL THICKNESS OF MAIN	GAS PRESSURE ON MAIN PSIG	LOCATION OF FRACTURE WELD ☐ NIPPLE ☐ MAIN ☐

DID WELD CONTAIN: PINHOLES COLDROLL UNDERCUT	DEPTH OF UNDERCUT	LENGTH OF UNDERCUT

REMARKS ON TEE WELD

PIPE WELD	QUALIFIED ☑ NOT QUALIFIED ☐	ELECTRIC ARC ☑ OX-ACETYLENE ☐	TEE WELD	QUALIFIED ☐ NOT QUALIFIED ☐	ELECTRIC ARC ☐ OX-ACETYLENE ☐
TESTED BY	SIGNATURE		TITLE		